

Date: Friday, 01/08/2008 3:28:44 PM
 User: Julie Lecocq

Process Sheet

SPLIT-2

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 40934		
Estimate Number	: 10255		
P.O. Number	:	Part Number	: D22301
This Issue	: 01/08/2008 S.O. No. :	Drawing Number	: D2230 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: F
Previous Run	: 39315	Material	:
Written By	:	Due Date	: 15/08/2008
Checked & Approved By	: <u>ILD 08 8 05</u>	Qty:	200 Um: Each
Comment	: Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total: 14.3430 f(s)
 Lug Extrusion D2423 Extrusion
 Batch: B33310

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut D2423 extrusion to 0.82"
 Batch: 1

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine per folio D2230-1
 (Check for crack while loading into the machine.)
 2-Tumble and deburr rough edges after tumbling

machine pending
D2230 REV F

08/08/06
200

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

read + inspect for stress damage
c/c attached

5.0	QC3	SECOND CHECK
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Comment: SECOND CHECK

08/08/08 +110

08/08/25 +90

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Job Number: 40934

Part Number: D22301

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



M.F. 08/09/11



(110X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0 QC5

INSPECT WORK TO CURRENT STEP



S. S. 08/08/07



Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING

POWDER COATING



M 108523



(90X)

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*10:30
320°F
11:00*

*10:15 AM
320°F
10:45 AM*

08-08-12 (X90)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M.F. 08/09/12



(110X)

Comment: INSPECT POWDER COAT

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST476

ST476

08/09/15 (110) - 80 ansil

08/08/21

(X90)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/16

Job Completion

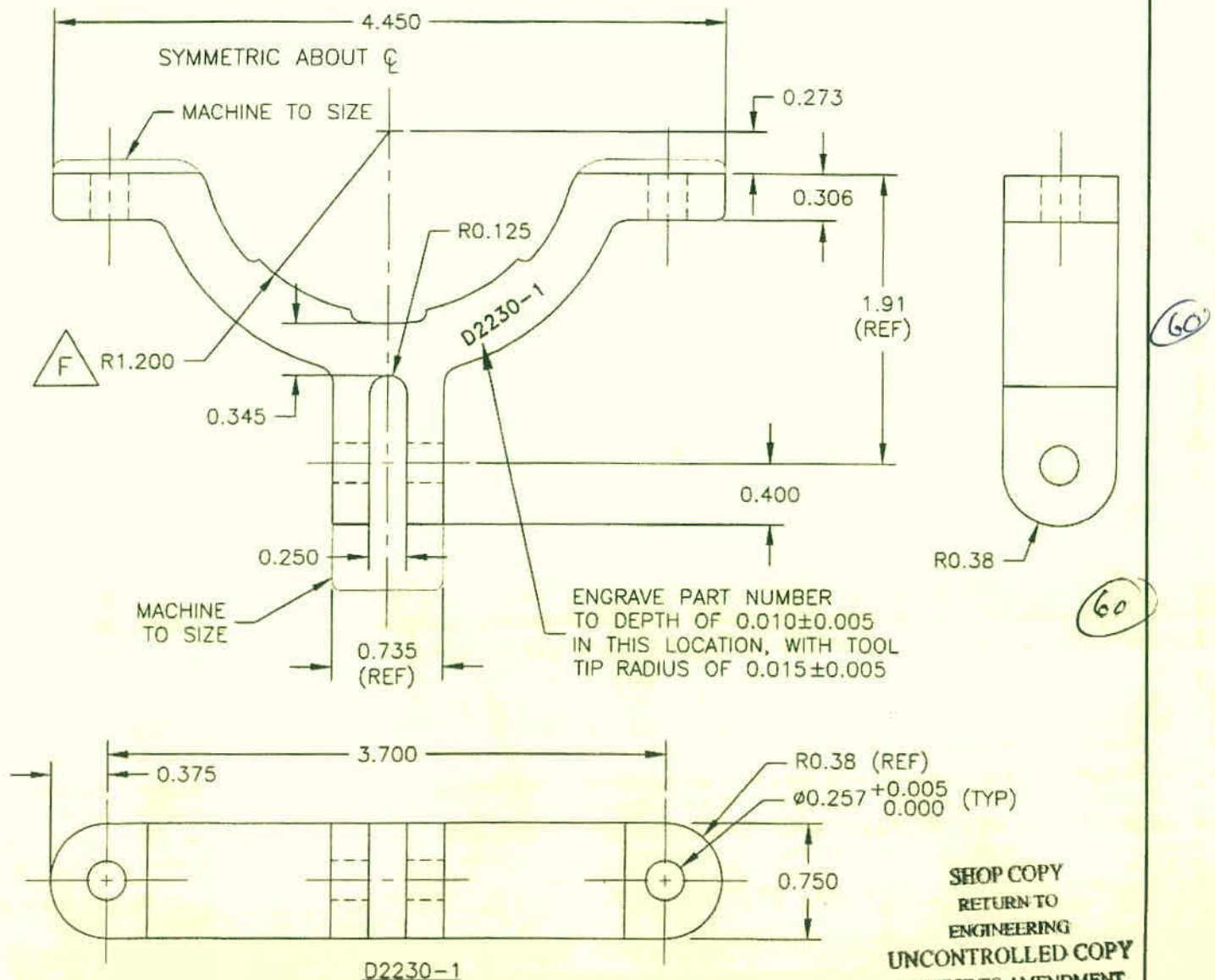


MF 08-09-15



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D2230
				REV. F
DATE	99.12.13	TITLE	MOUNTING LUG	SHEET 1 OF 2
				SCALE 1:1
C	94.03.30	RE-DESIGN		
D	95.01.04	RE-DESIGN		
E	95.01.04	RE-DESIGN		
F	99.12.13	REDESIGN; R1.200 WAS R1.100		

RELEASED
99.12.21 DS



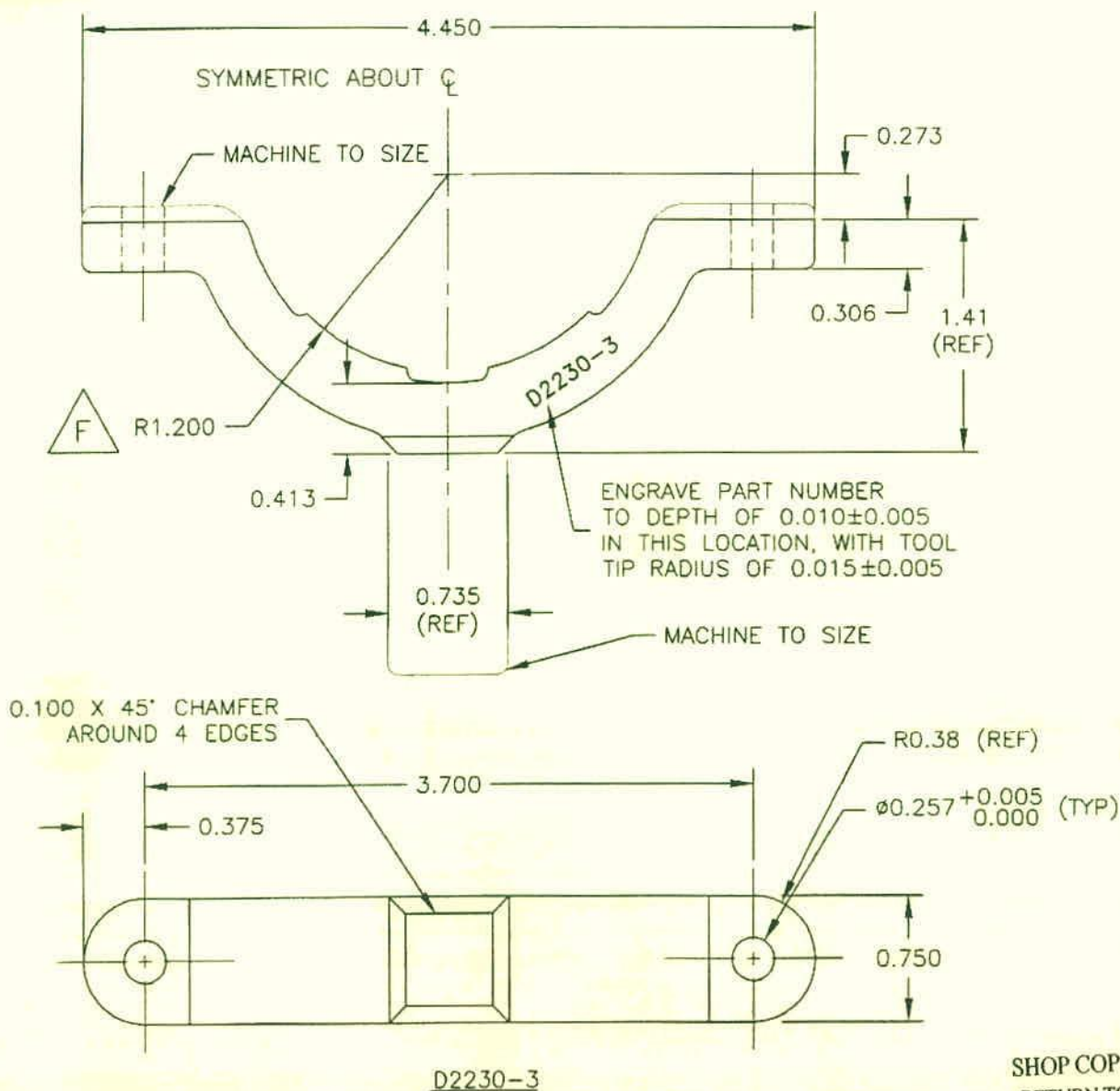
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40934



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
19.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 40934

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

110

D2230-1

Lug B40934

6881

MATERIAL supplied by DART D2423 B33310

S. Walz
02/09/08

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz
Shigi Walz

Vankleek Hill, September 5, 2008

